



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3440-7
Job Sheet 173248



Part No: D3440-7 **Job Qty:** 4 ea

Part Name: Detent Clip Base (Supersedes B67-43001-221)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 4/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP A 05.06.30 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	4/7/18	4/7/18	0.00	0.00	Start Up Machining-2		mark 18/04/18
100	Bandsaw	4 pcs	4/7/18	4/7/18	0.00	2.63	Bandsaw1		11
110	CNC Vertical Machining	4 pcs	4/9/18	4/9/18	0.00	2.63	HAAS1-3		11
130	QC	4 pcs	4/9/18	4/9/18	0.00	0.00	QC8 Machining-2		18-04-18
140	Packaging	4 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-1		18-04-19
150	QC21-SA	4 Ea	4/9/18	4/9/18	0.00	0.00	QC21		21

Part Op 100 - Cut blank: 1.250" x 1.500" x 2.200" long

Descriptions: 110 - Machine as per Folio FA537 and Dwg D3440 Dwg Rev: _____ Identify as D3440-7 Folio Rev: APR 2 2018

130 - QC8- Inspect parts - second check

140 - Identify as per dwg & Stock Location: _____

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X01.250	6061-T6 Bar 1.50 X 1.25	.7752 ft (.1938 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X01.250	1	14	0



Container No: S062003



Part: D3440-7

Job No: 173248

Serial No/Batch: S062003

Revision:

Inspector:

DART Aerospace Ltd.
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Date: 04/17/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Detent Clip Base	1.750inches $\pm$ 0.030	1.780 1.720		1.745
2	Detent Clip Base	0.130inches $\pm$ 0.030	0.160 0.100		.125
3	Detent Clip Base	0.750inches $\pm$ 0.030	0.780 0.720		0.745
4	Detent Clip Base	0.380inches $\pm$ 0.030	0.410 0.350		0.373
5	Detent Clip Base	0.190inches $\pm$ 0.030	0.220 0.160		.190
6	Detent Clip Base	0.500inches $\pm$ 0.030	0.530 0.470		0.499
7	Detent Clip Base	1.000inches $\pm$ 0.030	1.030 0.970		0.999
8	Detent Clip Base	2.000inches $\pm$ 0.030	2.030 1.970		1.996
9	Detent Clip Base	0.130inches $\pm$ 0.030	0.160 0.100		.125
10	Detent Clip Base	1.470inches $\pm$ 0.030	1.500 1.440		1.467
11	Detent Clip Base	1.000inches $\pm$ 0.030	1.030 0.970		0.999

Plex 2/27/18 11:44 AM Dart.Gagnon.Michelle